

31

Date: Monday, 7/16/2007 2:45:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 33556		
Estimate Number	: 10366		
P.O. Number	: <i>N/A</i>	Part Number	: D412742013
This Issue	: 7/16/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: <i>N/A</i>
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 33555	Drawing Revision	: <i>N/A</i>
	Type : LANDING GEAR	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/30/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG003

KS 07-07-26

①

2.0	33556A	FLOAT SKID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B *33556A**[Signature]*

3.0	D2571	Saddle, Fwd, Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside

1531647

✓

SP

4.0	D2572	Saddle, Fwd, In
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside

1531714

✓

SP

5.0	D2573	Saddle, Aft, Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2573 Saddle Aft Outside

33042

✓

7/7/2454

Date: Monday, 7/16/2007 2:45:31 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2574

Saddle Aft Outside

B31718 ✓

SG

7.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2747

Bolt

B31300 ✓

SG

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2876

Saddle Spacer

B31227 ✓

SG

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2877

Saddle Spacer

B30655 ✓

SG

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D3403-1

Bushing

B32888 ✓

SG

11.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3403-3

Bushing

B32889 ✓

7/7/24 SG

Date: Monday, 7/16/2007 2:45:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

1332890 ✓ 88

13.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

1332891 ✓ 59

14.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

1104936 ✓ 59

15.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

119529 ✓ 59

16.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

1100340 ✓ 50

17.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

1104289 ✓ 7/17/24 50

Date: Monday, 7/16/2007 2:45:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

41 32 AN960C416L

Washer

M104925 ✓

59

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

41 8 AN960C616L

Washer

M18822 ✓

50

20.0

AN960C716L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

M104923 ✓

50
M13542

21.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

Washer

M104936 ✓

59

22.0

NAS1515H4L

Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

41 32 NAS1515H4L

Washer

M104956 ✓

7/7/248

Date: Monday, 7/16/2007 2:45:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

NAS1515H6L

Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H6L

Washer

M18918 ✓

SP

24.0

NAS1515H7L

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H7L

Washer

M180727 ✓

SP

25.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

B30394 ✓

SP

26.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

B33519 ✓

SP

27.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

B33276 ✓

SP

28.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M101427 ✓

7/17/24 SP

Date: Monday, 7/16/2007 2:45:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33556

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Ex 07/08/07



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING-RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location:

REV: 0 07/08/07

SP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/07 (1)

Job Completion



07/08/07

Float Skid Ass: B33556A

Monday, 7/16/2007 2:45:46 PM
Kim Johnston

Process Sheet

31

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Job Number	: 33556A		
Estimate Number	: 10756		
P.O. Number	: N/A	Part Number	: D412742043
This Issue	: 7/16/2007 S.O. No. : N/A	Drawing Number	: D3391 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: F
Previous Run	: 33555A	Material	: N/A
Written By	: <u>JA 07.02.17</u>	Due Date	: 7/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 07.02.17</u>		
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM		
	: Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC		
	: Est Rev C 07-05-28 As per Rev F JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003 N/A

2.0 D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

B31312

JD

3.0 D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

B31859

DA

4.0 D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B31312

JD

07-07-24 ①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33556A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: ~~33814~~ B33764 ML 07 07 28

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 32738 ML 07 07 28

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: 33452 ML 07 07 28

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 33483 ML 07 07 28

9.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: 104955 ML 07 07 28

10.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: 103693 ML 07 07 28

11.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: 103608 ML 07 07 28

Date: Monday, 7/16/2007 2:45:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33556A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer:

Batch: 105057

MM 07 07 28

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M105085

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 1104989

Expiry date: Jan 1 2008

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon 104251

A/R Sikaflex-241/-291 104989

Expiry date: 01/2008

> MM 07 07 28

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

9207-07.300

M1104251

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan 30 0

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING-RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP 33556

CP 07/08/010

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070801	2						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: HA Date: 07.08.15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070801	7.0 2	Rubber Gasket was torn, so scrap + Replace	<i>[Signature]</i> 07/08/15	Replaced Gasket with good one B 33458	<i>M.H.</i> 07/08/15	<i>[Signature]</i> 07/08/15	<i>[Signature]</i> 07/08/15	<i>[Signature]</i> 07/08/15

NOTE: Date & initial all entries

Date: Monday, 7/16/2007 2:45:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33556A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



①

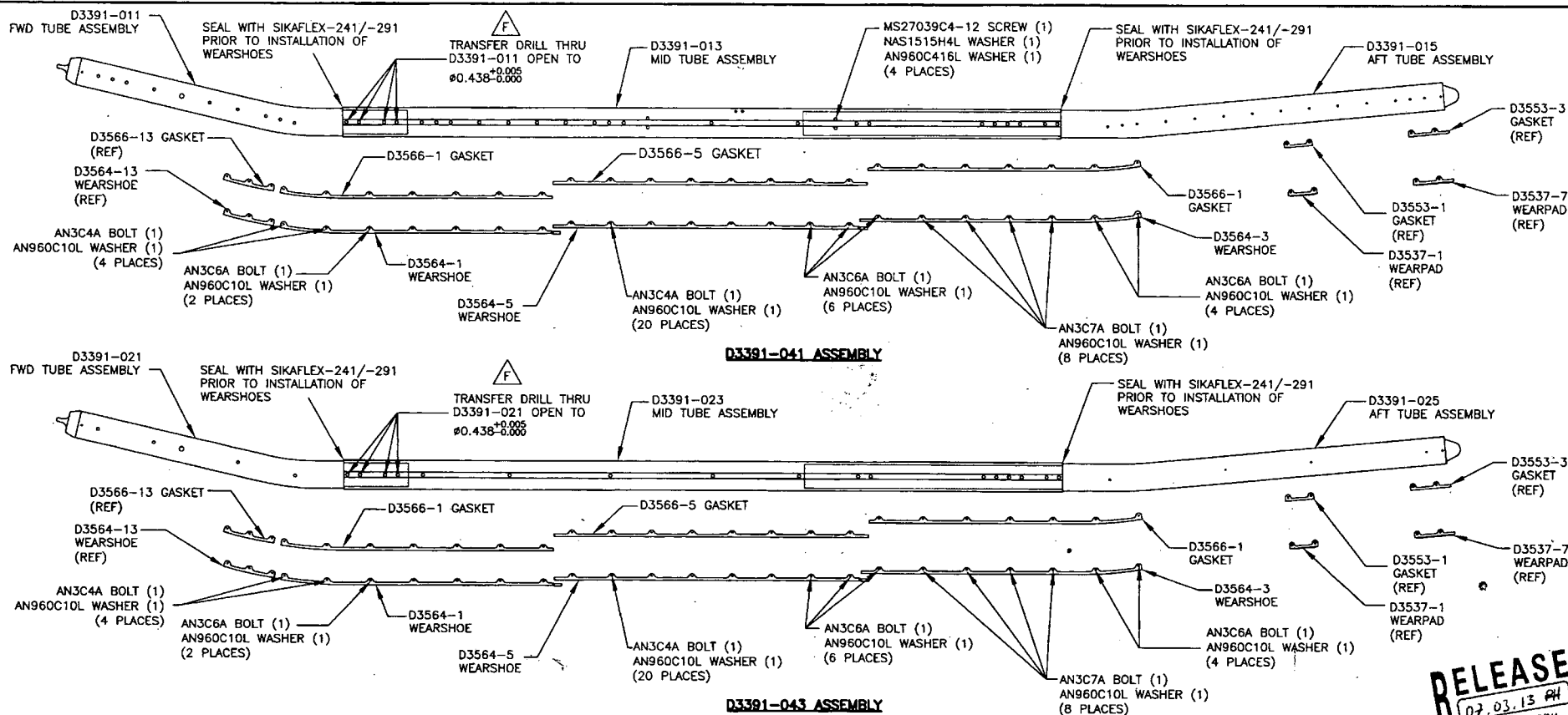
Comment: FINAL INSPECTION/W/O RELEASE

D 87160169

Job Completion



u 87.08.05



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	Float Skidtube Assembly
		D3391-043	Float Skidtube Assembly
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (0.250-0.257) FOR WEARSHOE INSERTS. C'SINK 0.391/0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

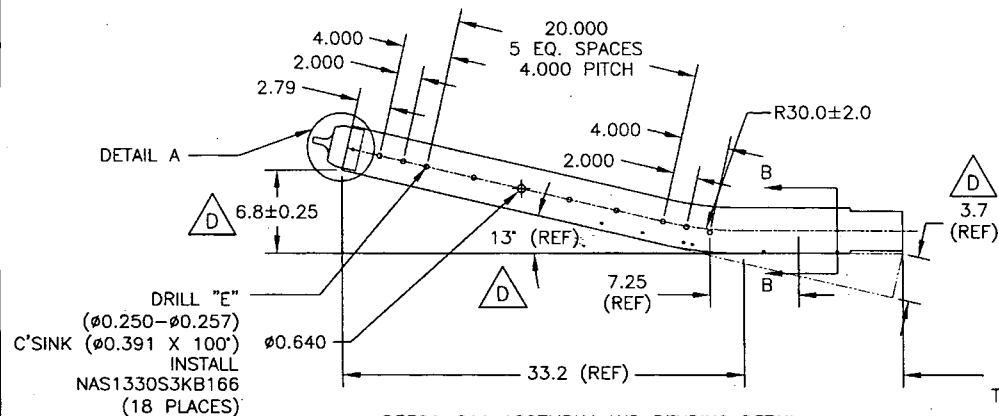
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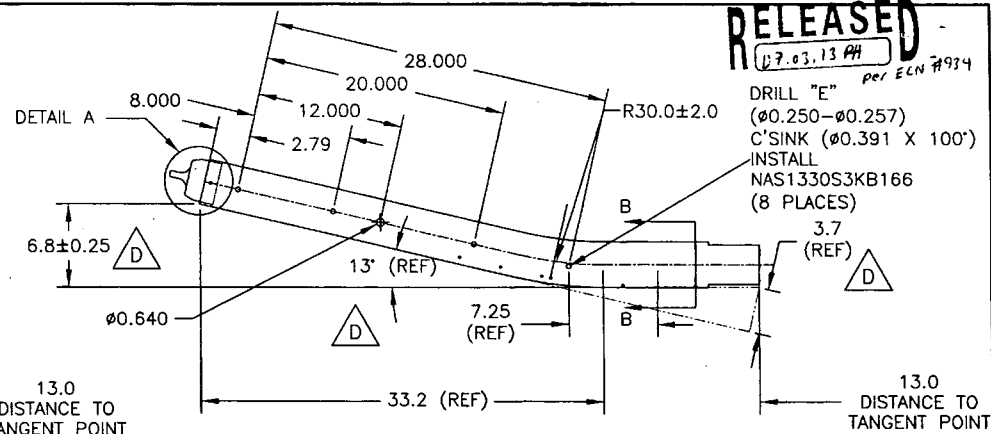
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3391
DATE	TITLE	SHEET 1 OF 5 412 FLOAT SKIDTUBE
07.01.18		SCALE NTS

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
33564

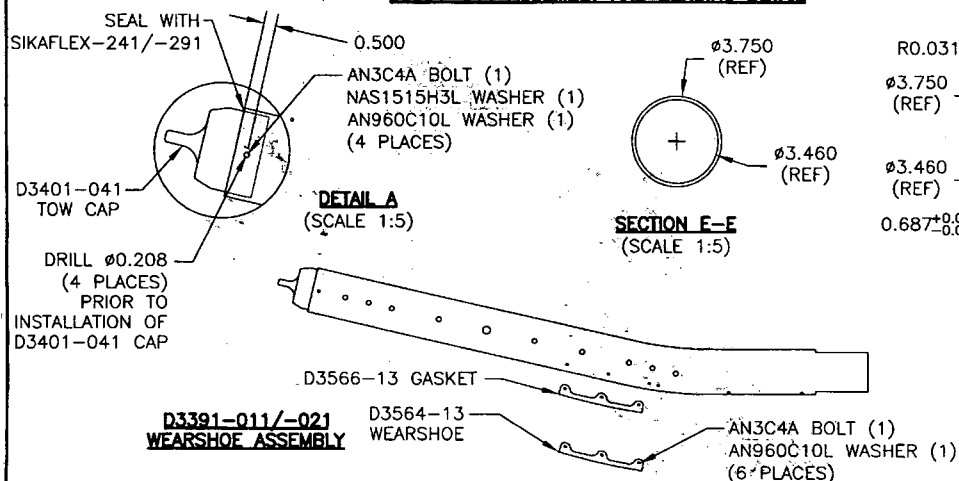
RELEASED
 127.03.13 AH
 per ECN #7974



D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL

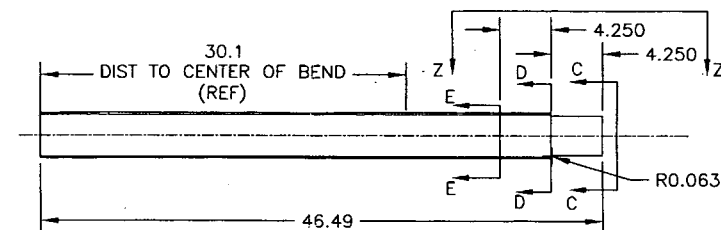


D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5
 DRILL "E"
 (0.250-0.257)
 C'SINK (0.391 X 100")
 INSTALL
 NAS1330S3KB166
 (12 PLACES)

SECTION B-B
 (SCALE 1:5)



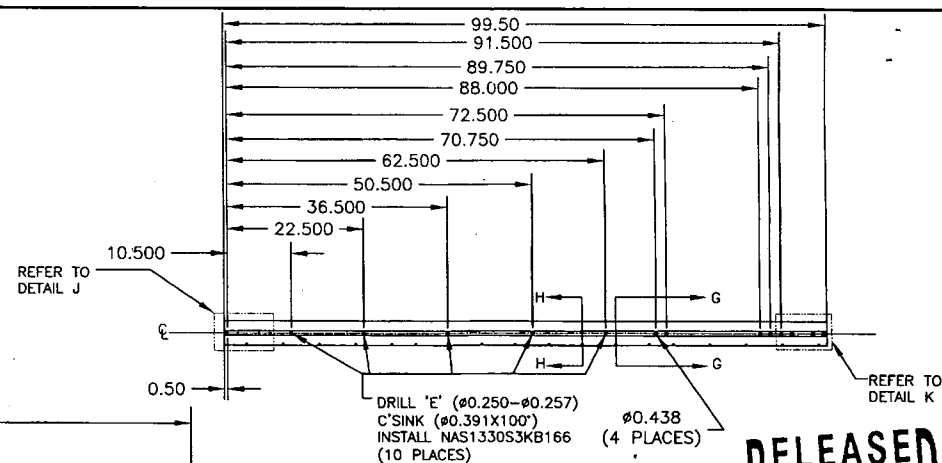
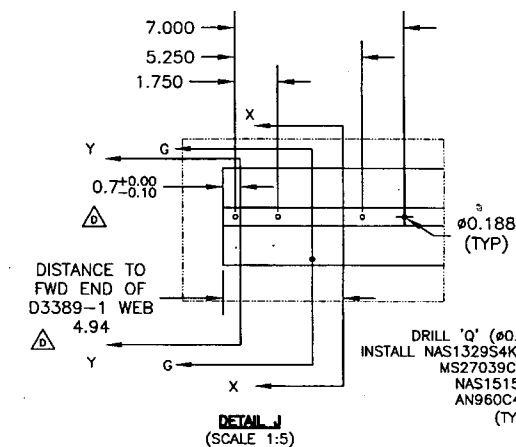
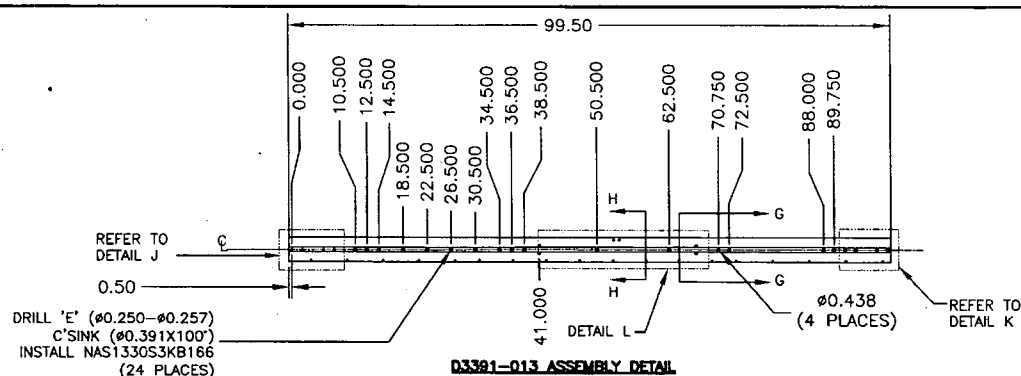
D3391-1 DRILLING AND CUTTING DETAIL
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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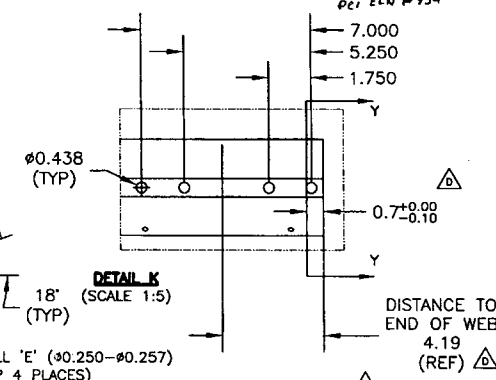
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DESIGN PH	DRAWN BY AH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED JH	APPROVED JH	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 2 OF 5 SCALE 1:10

NO. 3391-011
 WORK ORDER
 3391-011
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE



D3391-023 ASSEMBLY DETAIL



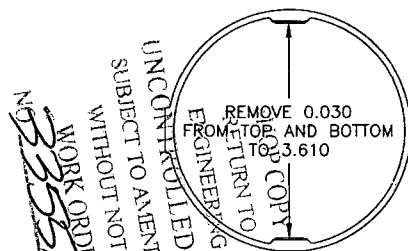
D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

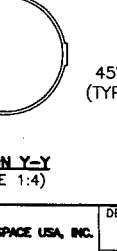
SECTION L-L
(SCALE 1:4)



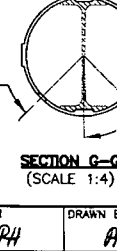
SECTION M-M
(SCALE 1:4)



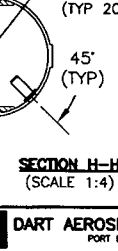
SECTION LL-LL
(SCALE 1:4)



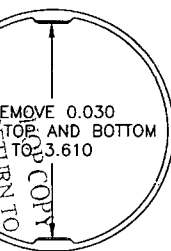
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)

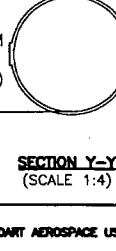


SECTION X-X
(SCALE 1:2)

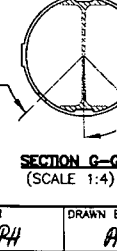


REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

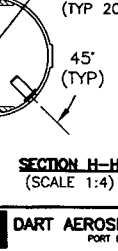
SECTION Y-Y
(SCALE 1:4)



SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



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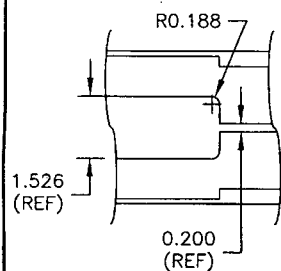
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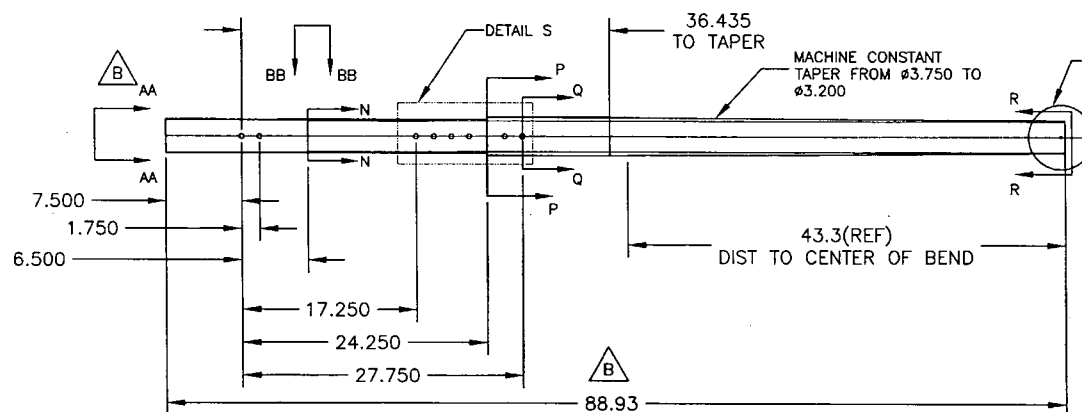
DESIGN
CHECKED
DATE
07.01.18

DRAWN BY
APPROVED
TITLE
412 FLOAT SKIDTUBE

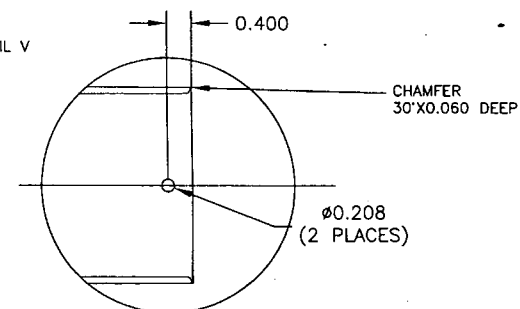
DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO.
D3391
REV. F
SHEET 3 OF 5
SCALE
1:20



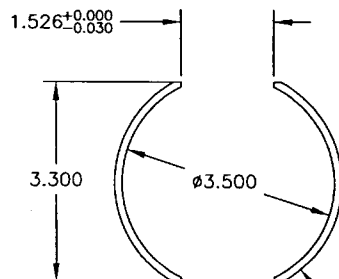
VIEW BB-BB
(SCALE 1:3)



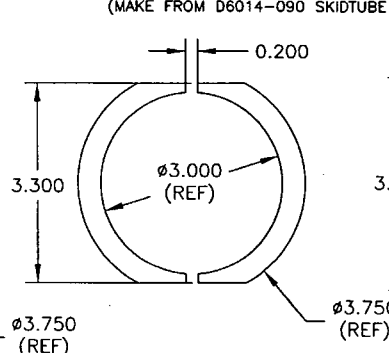
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



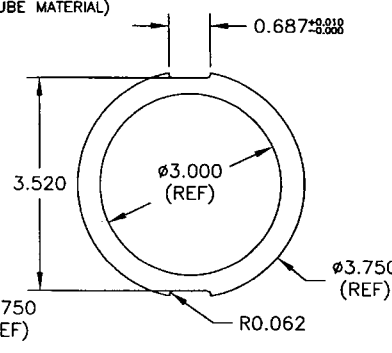
DETAIL V
(SCALE 1:2)



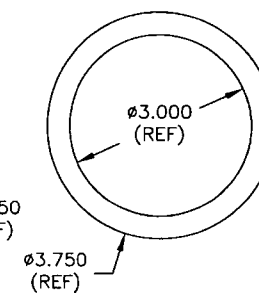
SECTION AA-AA
(SCALE 1:2)



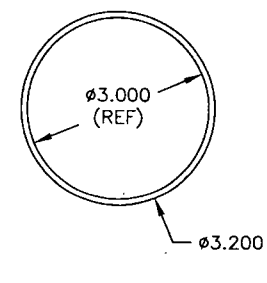
SECTION N-N
(SCALE 1:2)



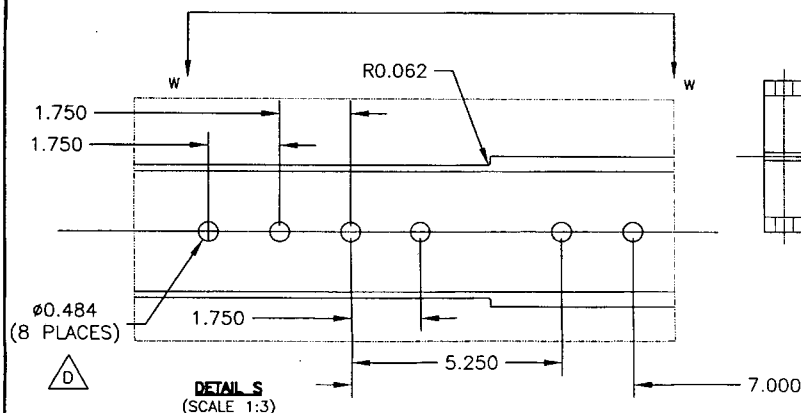
SECTION P-P
(SCALE 1:2)



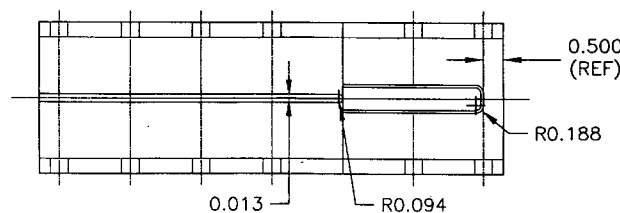
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

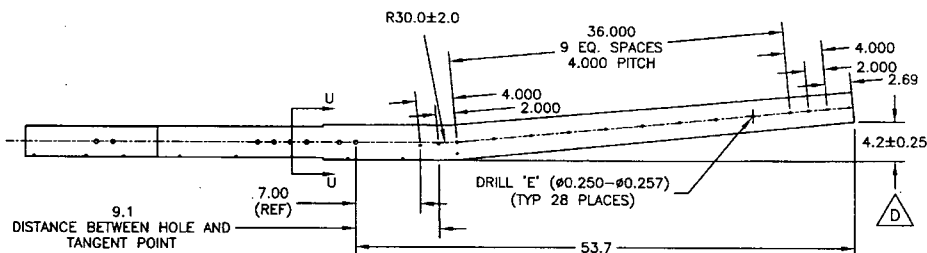
NO. 335564
WORLD ORDER
SUBJECT TO AN ENDORSEMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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07-05-13 PH
per ECU #934

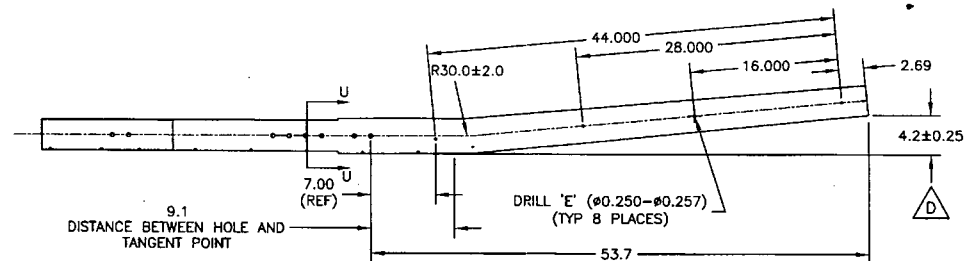
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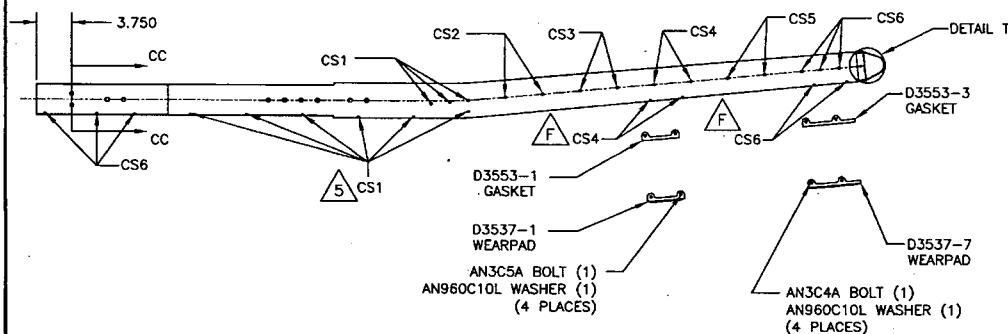
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED	APPROVED		
DATE	DRAWING NO.	D3391	SHEET 4 OF 5
07.01.18	TITLE		
	412 FLOAT SKIDTUBE		SCALE 1:12



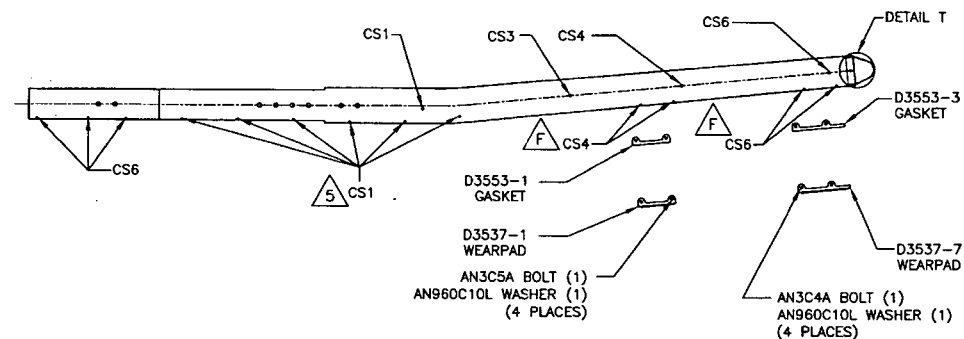
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



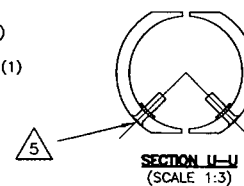
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
335564
18' (L)
ENGINEERING
SECTION CC-CC
(SCALE 1:3)

DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



SECTION U-U
(SCALE 1:3)

AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)
DETAIL T
(SCALE 1:3)
D2646 AFT CAP
SEAL WITH
SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

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